

Work Order ID 66643

Wednesday, February 23, 2011 11:36:37 AM



Page 1

Item ID: D2804-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket Assembly

Start Date: 2/23/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 11-02-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2804

Rev C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Press D2805-2 into arm as per Dwg D2804

11/02/23 *(Signature)*

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 Nov 173

(X9)

012

120

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

11:30

OVEN TEMPERATURE:

320 FINISH TIME:

12100

PH BL 11-2-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

4 6 22 11/02/25

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Press Fit D2809 as per Dwg D2804

ES 11/02/25

150

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 □2-Assemble as per Dwg D2804.

ES 11/02/25

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/11/02/05

(74)

-042

170

Identify as per dwg & Stock Location: 150

0.00



Packaging

Memo

0.00

Packaging

11/2/02 (40) SP

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/01

-C211/03/01

W/O:		WORK ORDER CHANGES					
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Picklist Print

Wednesday, February 23, 2011 11:36:46 AM

Page 1

Work Order ID: 66643

Parent Item: D2804-042

Parent Item Name: Bracket Assembly



Start Date: 2/23/2011

Required Date: 2/25/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP F05.03.30MS21043-3 was MS21042L3 KJ/JLM
IPP Rev:G As per Rev C 06-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2804-2 Bracket		Manufactured	No			100	Each	5.0000	1	4			
<div> <div> <u>Location</u> ST149 46613 </div> <div> <u>Loc Qty</u> 5 5 </div> <div> <u>Loc Code</u> </div> </div>													
D2805-2 Stop		Manufactured	No			100	Each	8.0000	1	4			
<div> <div> <u>Location</u> ST024 64454 </div> <div> <u>Loc Qty</u> 8 8 </div> <div> <u>Loc Code</u> </div> </div>													
NAS1515H3 Washer		Purchased	No			100	Each	150.0000	4	16			
<div> <div> <u>Location</u> ST277 115935 116373 </div> <div> <u>Loc Qty</u> 150 50 100 </div> <div> <u>Loc Code</u> </div> </div>													
AN3C16A Bolt		Purchased	No			150	Each	55.0000	2	8			
<div> <div> <u>Location</u> ST352 111193 111425 115835 </div> <div> <u>Loc Qty</u> 55 6 5 44 </div> <div> <u>Loc Code</u> </div> </div>													

ES 11/02/23
B64769 (42)

ES 11/02/23

4
16
11/2/24 SP

8
11/2/24 SP (42)

7

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Page 2

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Parent Item: D2804-042

Parent Item Name: Bracket Assembly

Start Date: 2/23/2011

Required Date: 2/25/2011

Start Qty: 4.00

Required Qty: 4.00

D2809

Manufactured No

150 Each

17.0000 1



Bushing



4
9/5/11/02/25

Location

Loc Qty

Loc Code

ST025

17

34035

12

46438

1

47733

4

MS21043-3

Purchased No

150 Each

1,270.000 2



Nut



8
11/2/11 sl (40)

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1194

112314

1194

8

Wednesday, February 23, 2011 11:36:46 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

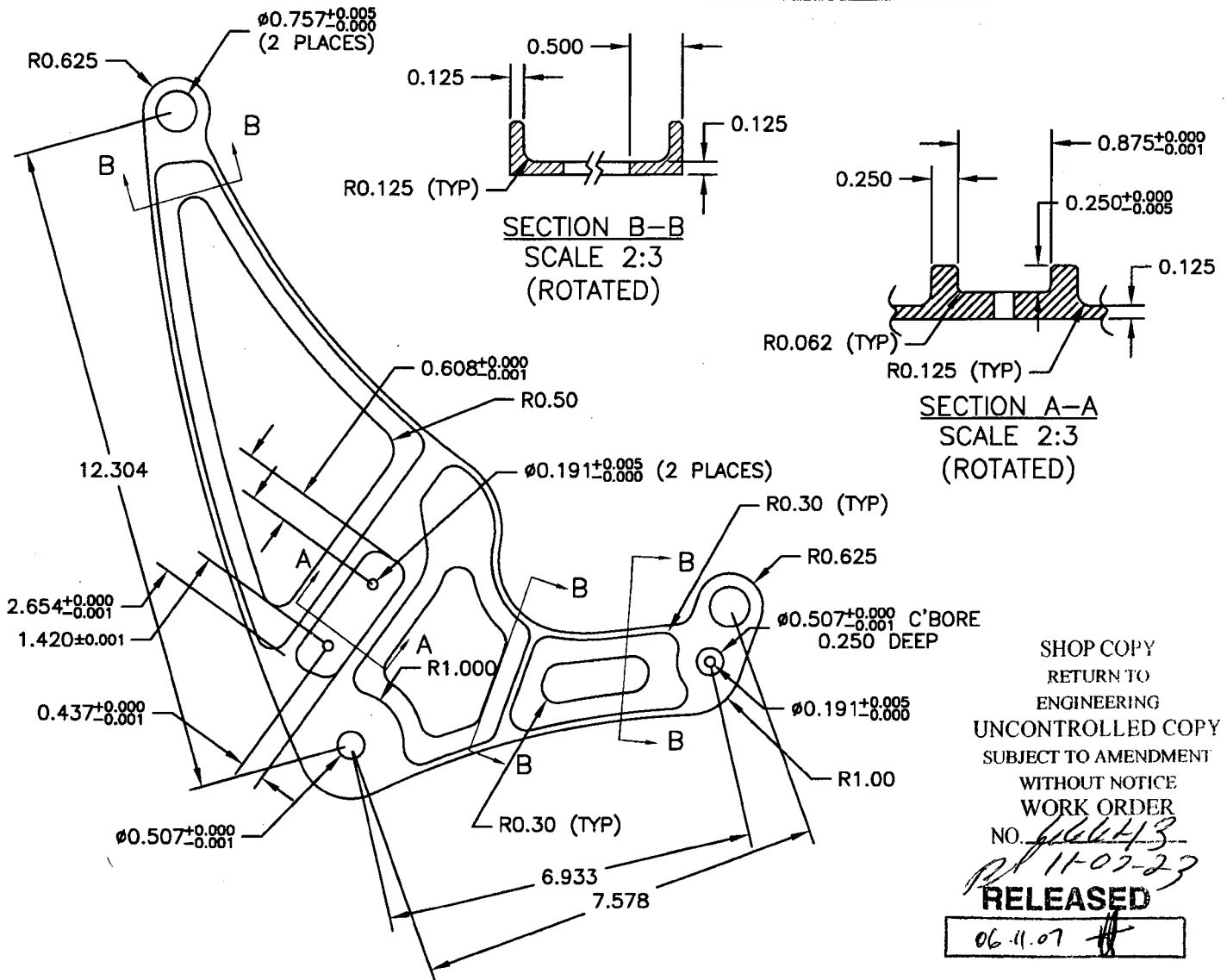
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	
C	06.10.16	CHANGE GEOM. TO ADD CLEARANCE	

**D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)**

- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

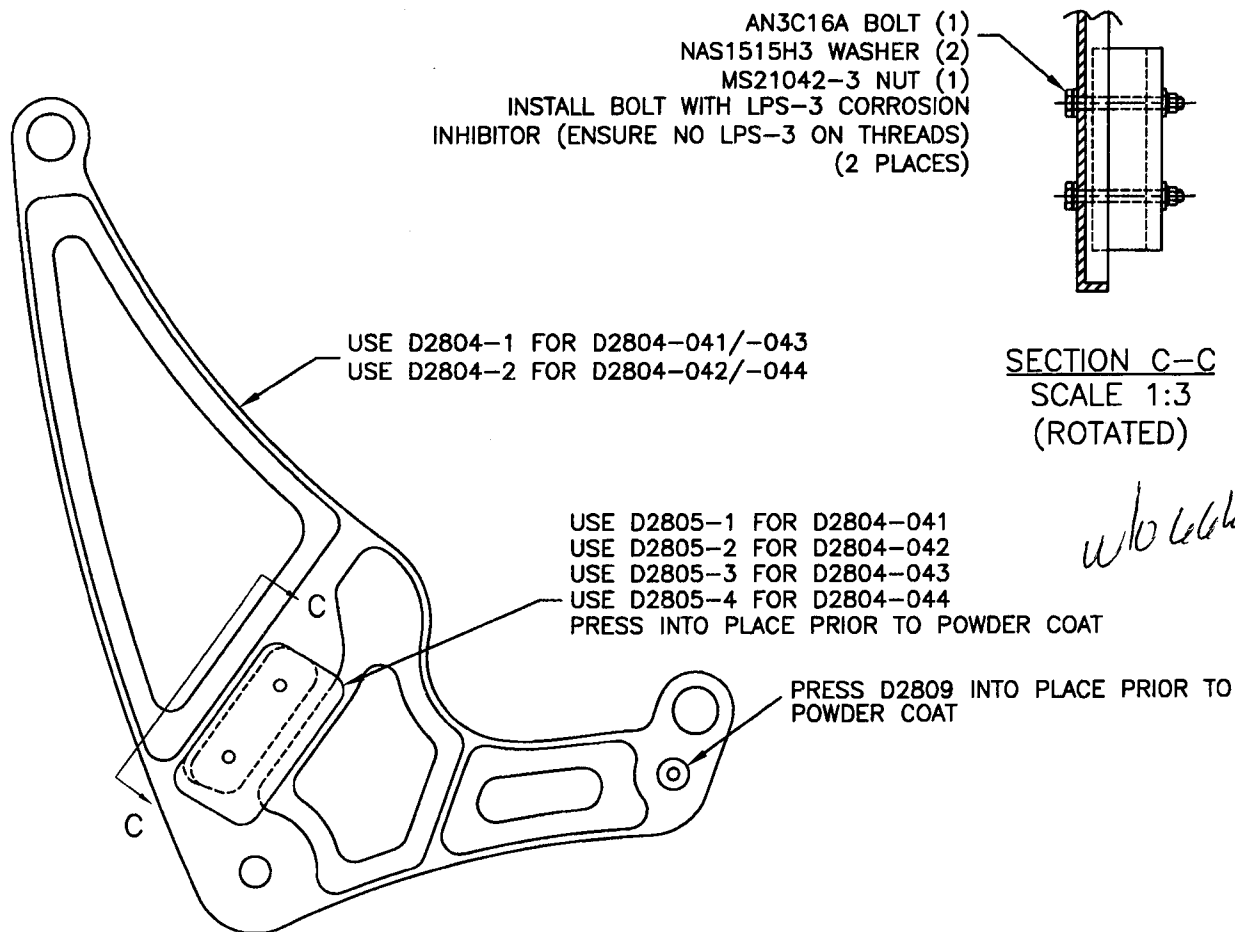
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



D2804-041/-043 BRACKET ASS'Y (SHOWN).

D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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